

Date: Friday, 2/23/2007 8:32:11 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 30895		
Estimate Number	: 10493		
P.O. Number	: <u>N/A</u>	Part Number	: D32043
This Issue	: 2/23/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3204 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: <u>N/A</u>	Material	: <u>N/A</u>
Written By	:	Due Date	: 3/21/2007 Qty: 8 Um: Each
Checked & Approved By	: <u>SA 02.02.23</u>		
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X02000	6061-T6 Bar .50" x 2.0"
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Comment: Qty.: 0.5815 f(s)/Unit Total : 4.6519 f(s)
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)
 (M6061T6B0.500x02.000) Batch: 175801

SA 02/03/19

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

SA 02/03/19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA344 and Dwg D3204
 2- Deburr
 Identify as D3204-3

SA 07.03.21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.03.21

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JF 07/03/21 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 30895

Part Number: D32043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/8/21

(S)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

RD 07/03/22

Job Completion



U 07-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30895
Description: Arm		Part Number:	D3204-3
Inspection Dwg: D3204 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	6.00	/			
5.25	+/-0.030	5.25	/			
0.776	+/-0.010	.775	/			
Ø0.760	+0.005/-0.000	Ø.760	/			
0.080	+/-0.010	.084	/			
R0.50	+/-0.010	R.50	/			
2.373	+/-0.010	2.373	/			
0.750	+/-0.010	.730	/			
R0.380	+/-0.010	R.375	/			
Ø0.375	+0.001/-0.000	Ø.375	/			
0.300	+/-0.010	.302	/			

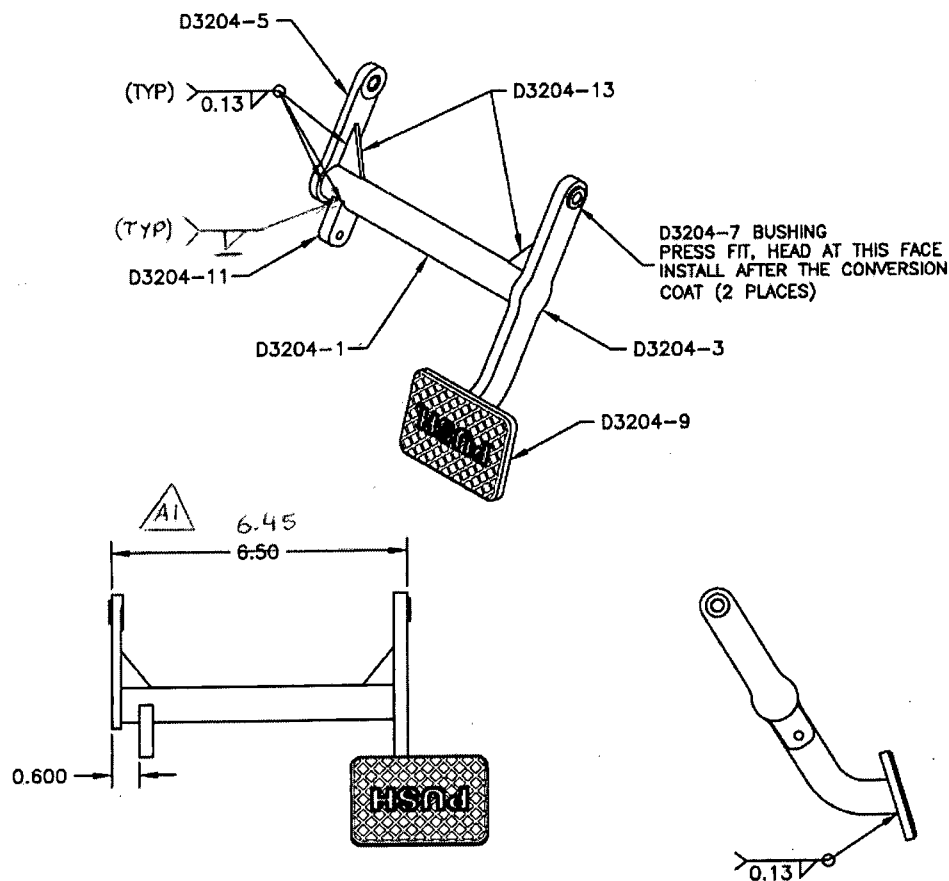
Measured by:	SD	Audited by:	Er	Prototype Approval:	N/A
Date:	07.03.21	Date:	07.03.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
07.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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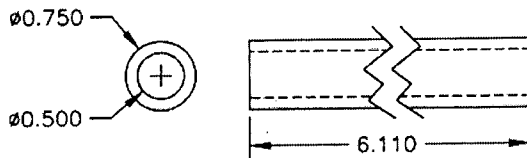
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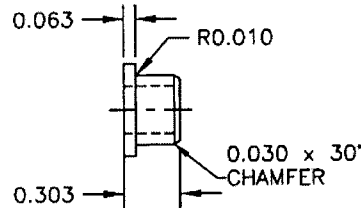


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

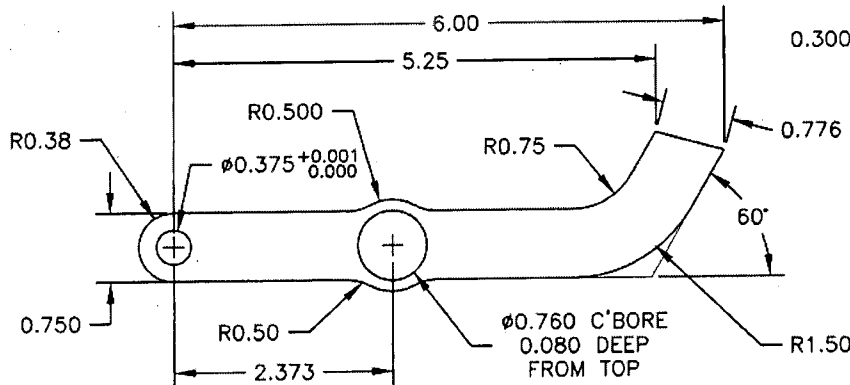
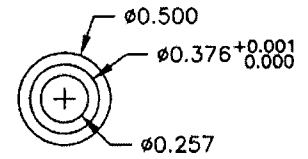
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04.04.05



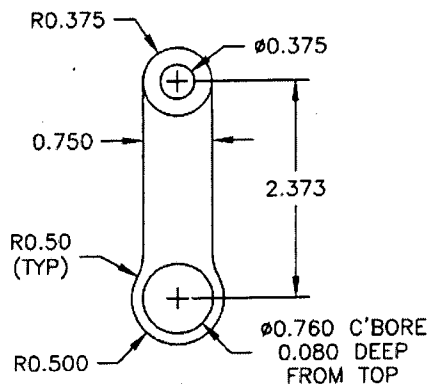
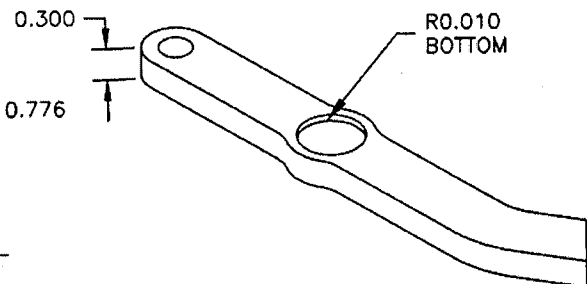
2 D3204-1 TUBE
SCALE 1:2



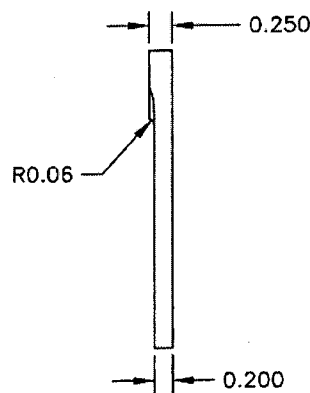
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



6-368
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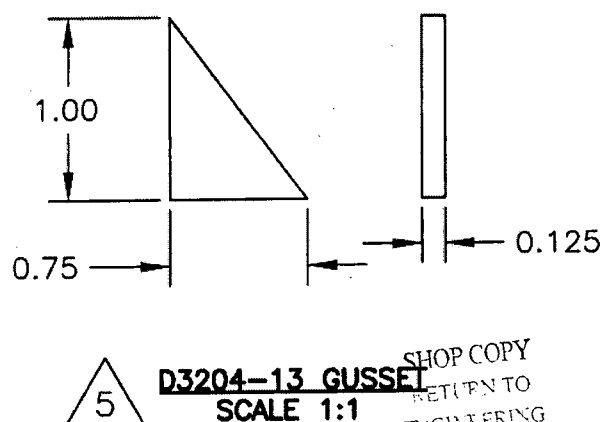
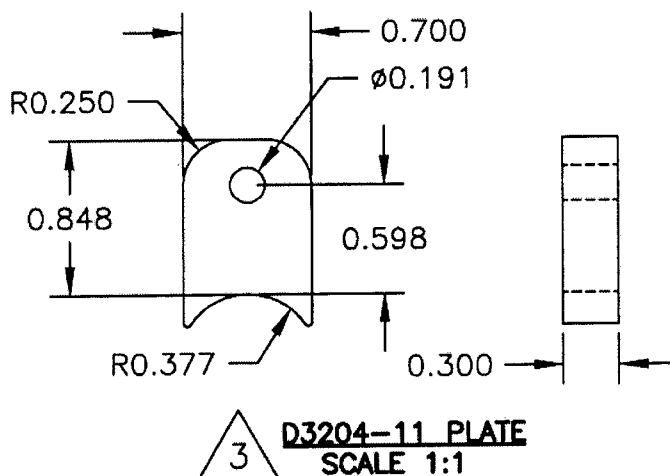
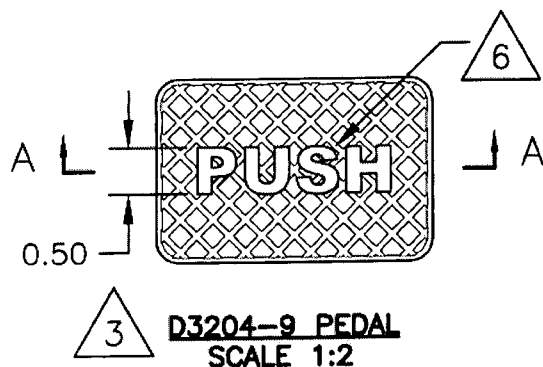
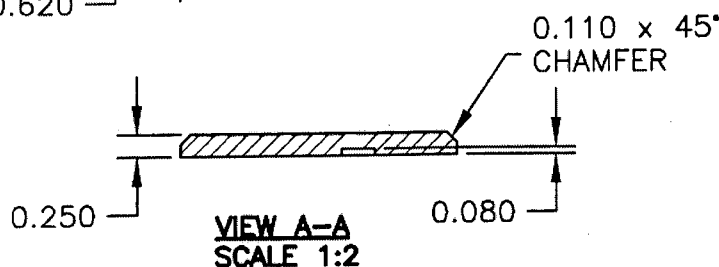
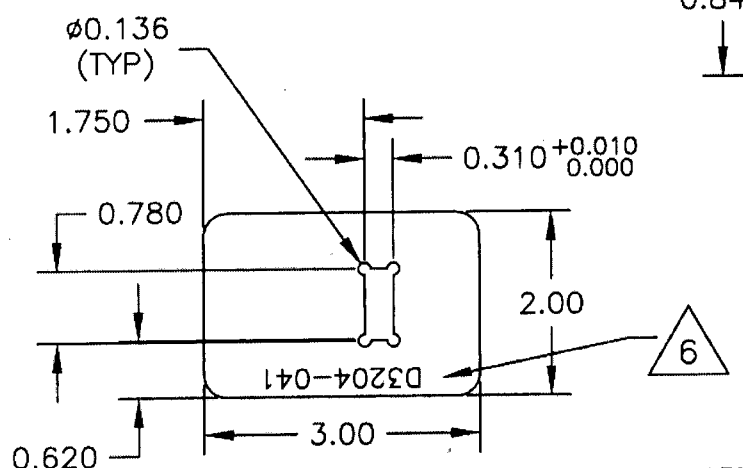
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CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

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04.04.30



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